

# Work Order ID 74995

October-14-11 11:24:28 AM

**\*74995\***

Page 1

Item ID: D3325-041  
Revision ID:  
Item Name: Basket Lid Assembly

Accept

**\*N900040100\***

Setup Start **\*NS1\***  
Stop **\*NS2\***

Start Date: 10/14/11 Start Qty: 1.00 **\*1\***  
Required Date: 10/21/11 Req'd Qty: 1.00 **\*1\***  
Reference:

Cust Item ID:  
Customer:

Approvals: Process Plan:  Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3325	Rev B

100		0.00
<b>*100*</b>	Large Fab	
Large Fab		0.00
Large Fab	Memo	
	1-Cut tubes as per Dwg D3325	

Qty	Part Number	Description	Batch
2	D3325-1	End Tube	<u>4119683</u>
3	D3325-3	Interior Tube	<u>4119683</u>
2	D3325-5	Full Length Tube	<u>4119683</u>

Identify parts appropriately

2-Remove all markings from material

3-Drill and Weld as per Dwg D3325 & QSI 004  
A/R4130 Steel Rod 41000 75

4-Deburr as required

Ph →  
12-05-08 (12)

W/O: 74995		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/01/14	#100	L.D must match D3324-041 B 72378 Base.					

Part No: D 3325-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		L.D must match. Base. D3324-041 B 72378						

**NOTE:** Date & initial all entries

**Work Order ID 74995**

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**\*74995\***

Page 2

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**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***Start Date: 10/14/11 Start Qty: 1.00 **\*1\***Required Date: 10/21/11 Req'd Qty: 1.00 **\*1\***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date:  
QC: Date:

Tooling: Date:  
SPC (Y/N): Date:

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*110\***

QC

Memo

0.00

Quality Control

1 7 0 SE 12/05/08

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

Stamps

Ⓢ

121

Pressure Wash per QSI005 4.3

0.00

**\*121\***

HandFinish

Memo

0.00

Hand Finishing

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Page 3

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Reference:

Cust Item ID:  
Customer:

Approvals: Process Plan:  
QC:

Date:  
Date:

Tooling:  
SPC (Y/N):

Date:  
Date:

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*130\***

Powdercoat

Powder Coating

Memo

0.00

1ST COAT:

START TIME: 8-15

OVEN TEMPERATURE: 400 F

FINISH TIME: 8-45

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME: 9-10

OVEN TEMPERATURE: 400 F

FINISH TIME: 9-40

140

QC3- Inspect Part Finish

0.00

**\*140\***

QC

Quality Control

Memo

0.00

IX  M-L  
12/05/09

1  BLD-5-9.

M121134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

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Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

150

Identify as per dwg & Stock Location: **D350-720-041**

**72377**

**\*150\***

Packaging

Memo

0.00

1 0 12-5-9

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

12/05/10  
MLW 12/05/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

October-14-11 11:24:28 AM

Page 1

Work Order ID: 74995

Parent Item: D3325-041

Parent Item Name: Basket Lid Assembly

Start Date: 10/14/11

Required Date: 10/21/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A05.02.09New issueKJ/JLM  
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D3328-1 Basket Hinge		Manufactured	No			100	Each	23.0000	2	2		12.05.07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		23							
				33871		23			2x				
✓ D3349-1 Spacer Bushing		Manufactured	No			100	Each	28.0000	2	2		12.05.07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		28							
				44401		28			2x				
✓ D3352-1 Label Plate		Manufactured	No			100	Each	14.0000	1	1		12.05.07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		14							
				41925		14			1x				
✓ D3367-1 Mounting Bracket		Manufactured	No			100	Each	20.0000	2	2		12.05.07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		20							
				43228		20							
✓ M4130NTS0.500W.035 4130 Square tube .500 x .500 x .035w		Purchased	No			100	f	270.9988	20.5416	21.622737		12.05.07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT034		270.9988							
				109127		216							
				109385		15.75							
				112786		39.2488							

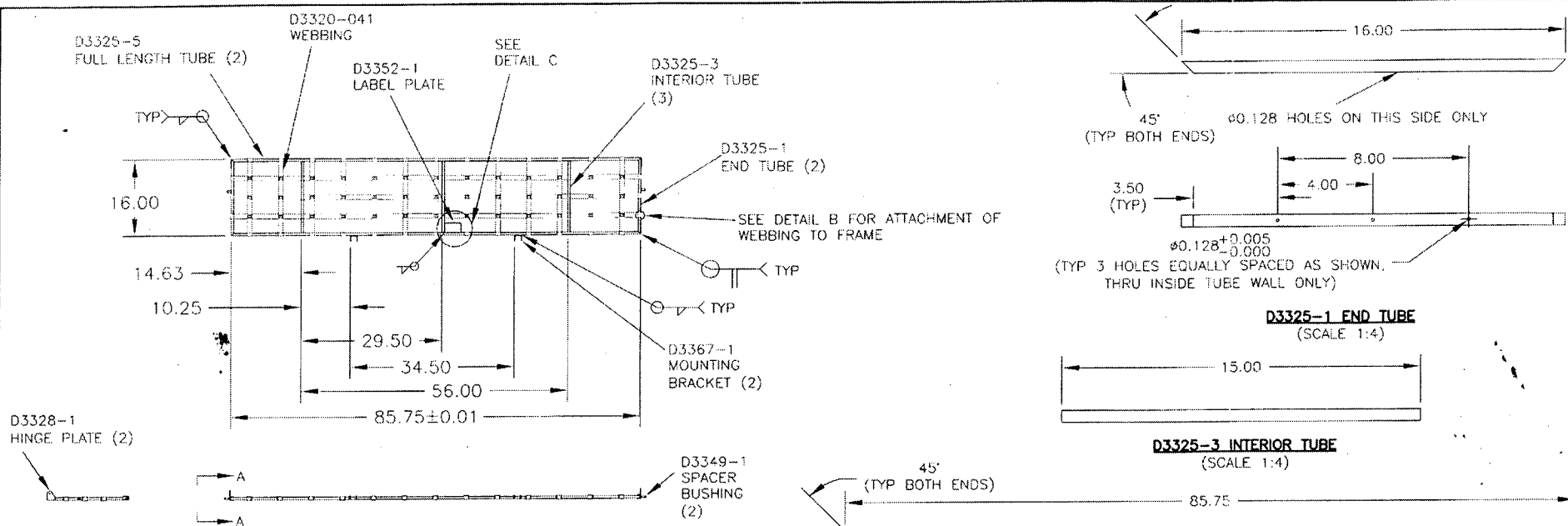
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



#### D3325-041 BASKET LID ASSEMBLY

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 (PRIOR TO INSTALLATION OF D3320-041)
- 2) WELD PER DART QSI 004
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

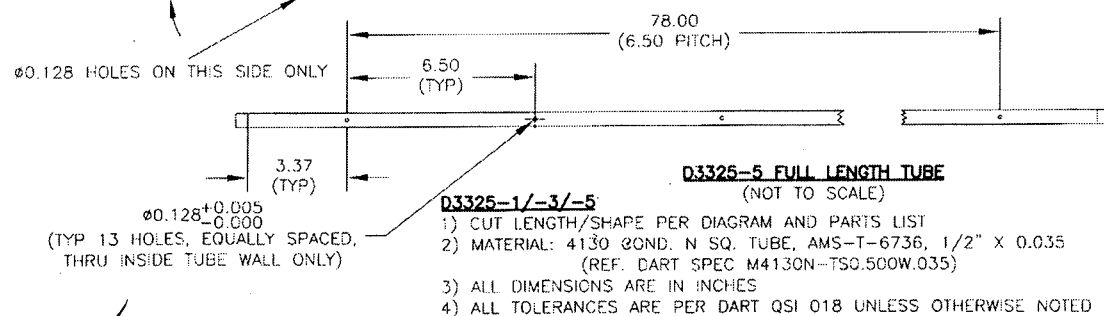
#### PARTS LIST FOR D3325-041 BASKET LID ASSEMBLY

Part No.	Quantity	Description
D2729-1	1	PRODUCT ID LABEL
D3320-041	1	WEBBING
D3325-1	2	END TUBE
D3325-3	3	INTERIOR TUBE
D3325-5	2	FULL LENGTH TUBE
D3328-1	2	HINGE PLATE
D3349-1	2	SPACER BUSHING
D3351-1	1	PLACARD
D3352-1	1	LABEL PLATE
D3367-1	2	MOUNTING BRACKET
MS20600AD4W3	32	RIVET
AN960JD9	32	WASHER

RELEASED

DEO ATTACHED

*Handwritten signature/initials*



#### D3325-1/-3/-5

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 ØOND. N SQ. TUBE, AMS-T-6736, 1/2" X 0.035 (REF. DART SPEC M4130N-TSO.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B.	05.04.25	CHANGE RIVET AND HOLE DIAMETER
A	04.10.21	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD. LAWRENCEVILLE, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3325
DATE	05.04.25	TITLE BASKET LID ASSEMBLY
		SHEET 1 OF 3
		SCALE 1:20

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

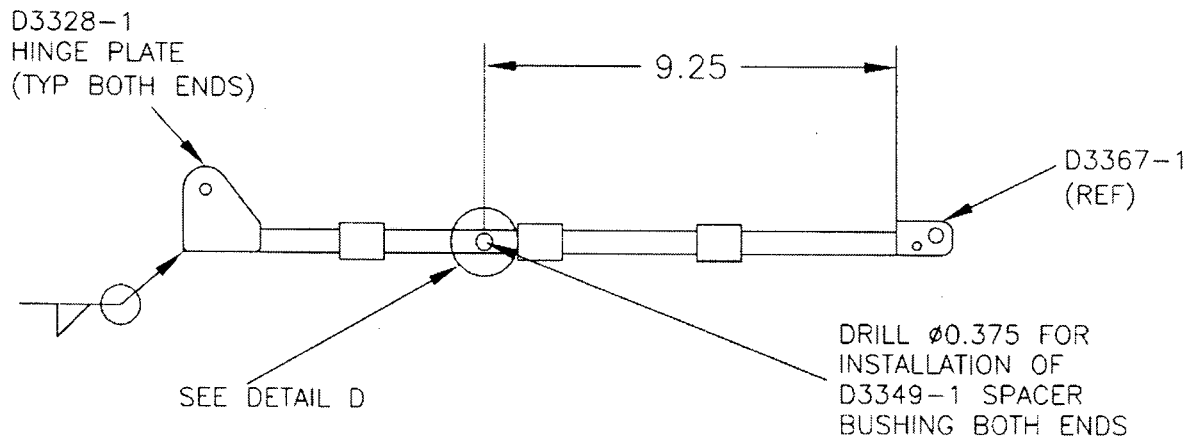
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

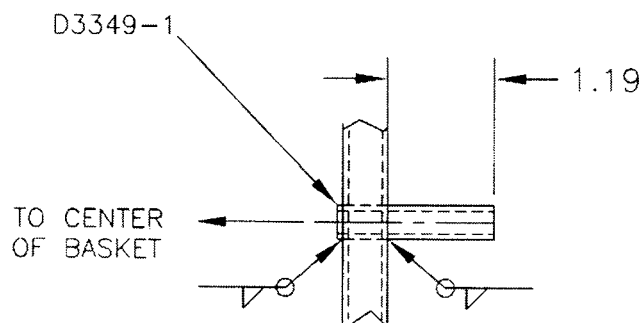
**NOTE:** Date & initial all entries



DESIGN AH	DRAWN BY FH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3325	REV. B SHEET 2 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4



VIEW A-A



DETAIL D  
(SCALE 1:2)

DEO ATTACHED

RELEASED  
05.04.28

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

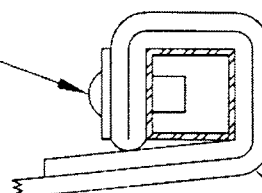
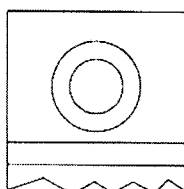
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3325	REV. B SHEET 3 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

MS20600AD4W3 RIVET (1)  
AN960JD9 WASHER (1)



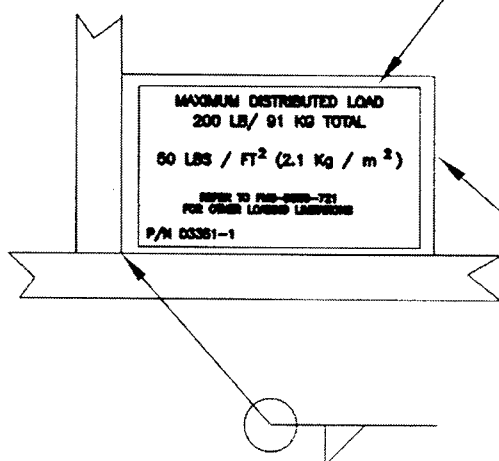
DETAIL B  
TYP. ATTACHMENT OF WEBBING TO LID  
FRAME  
(SCALE 1:1)

D3320-041 WEBBING

RELEASED  
05.04.25

DEO ATTACHED

ATTACH D3351-1 PLACARD  
ON TOPSIDE OF D3352-1



D3352-1

OUTBOARD

IDENTIFY WITH DART P/N  
D350-721-041 USING  
D2729-1 PRODUCT ID LABEL  
INSTALLED ON UNDERSIDE OF  
D3352-1

DETAIL C  
LABEL PLATE ATTACHMENT  
(SCALE 1:2)

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DRAWING NO. D3325	TITLE BASKET LID ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3325-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 08.11.28	DATE 08.11.28	DATE 08.12.01	DATE 08.12.01		DATE 08.12.01		

1) SHEET 1 MODIFY PARTS LIST AS SHOWN:

**PART LIST FOR D3325-041 BASKET LID ASSEMBLY**

Part No.	Quantity	Description

**IS:**

MS20600AD4W5	32	RIVET

**WAS:**

MS20600AD4W3	32	RIVET

2) UPDATE SHEET 3 DETAIL B ACCORDINGLY.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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David

No there is no inspection before the mesh gets welded on. For this time I believe all this is due to rushing and truly lack of attention.

We will (Marc, me, and David Duval) look into making a inspection before the mesh gets welded on. If we decide that this is necessary would you apply this to all baskets?

Downing

Sent from my iPhone

On 2011-10-13, at 4:15 PM, "David Shepherd" <[dshepherd@dartaero.com](mailto:dshepherd@dartaero.com)> wrote:

Marc.

As discussed, it appears that the middle ribs have been installed in reverse so that the larger gap is in the back rather than the front. As long as the ribs that are used to mount the basket to the helicopter are in the right place (ie. 15" from each end and 56" apart), I believe we can accept this basket as a deviation.

It probably makes sense to modify the lid so that all the frames line up for aesthetic reasons as you have recommended.

Eric.

At some level, there is a lack of attention to detail on this. Is there an inspection of the frame before all the mesh gets welded on? Might make it easier to correct a mistake in the future. Perhaps a PAR is required?

David

**From:** Marc Bellavance [<mailto:mbellavance@dartaero.com>]  
**Sent:** October-13-11 1:26 PM  
**To:** Shepherd, David  
**Cc:** Downing, Eric; Lacelle, Linda; Fauteux, Melanie  
**Subject:** D350-721-041

Hi David,

→ Please see attached picture. The rib shown on the basket base is not located per drawing. It is at 26.5" in lieu of 29.5". Instead of scrapping the basket base, we thought that perhaps we could authorize manufacturing of a custom made lid to match the base or mod the one seen in the picture. If this is acceptable, Eric D suggested that the label plate be welded on opposite side of rib as shown in the picture so it doesn't interfere with the installation of the webbing after powder coat. What are your thoughts on this?

Thanks,

Marc Bellavance Technical/Shop Support T. 613-632-5200 C. 613-676-0992 F. 613-632-9311 1270 Aberdeen Street, Hawkesbury, Ontario, Canada, K6A 2K7

<image001.jpg> **Product Documentation: Verify Revision Status/Download HERE!**

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## Linda Lacelle

---

**From:** dshepherd@dartaero.com  
**Sent:** October-14-11 9:36 AM  
**To:** Linda Lacelle; 'Eric Downing'  
**Cc:** 'Marc Bellavance'; 'Fauteux, Melanie'; 'Susanne Sheldon'; Bill Beckett; Mike Petsche  
**Subject:** Re: D350-721-041

All the more reason to inspect it properly along the way ...

Sent from my BlackBerry device on the Rogers Wireless Network

---

**From:** "Linda Lacelle" <llacelle@dartaero.com>  
**Date:** Fri, 14 Oct 2011 06:06:41 -0400  
**To:** <dshepherd@dartaero.com>; 'Eric Downing' <edowning@dartaero.com>  
**Cc:** 'Marc Bellavance' <mbellavance@dartaero.com>; 'Fauteux, Melanie' <mfauteux@dartaero.com>; 'Susanne Sheldon' <ssheldon@dartaero.com>; 'Bill Beckett' <bbeckett@dartaero.com>; 'Mike Petsche' <mpetsche@dartaero.com>  
**Subject:** RE: D350-721-041

Btw, there was no rush on this basket, it's going to stk  
LL

**From:** dshepherd@dartaero.com [mailto:dshepherd@dartaero.com]  
**Sent:** October-13-11 7:42 PM  
**To:** Eric Downing  
**Cc:** Marc Bellavance; Lacelle, Linda; Fauteux, Melanie; Susanne Sheldon; Bill Beckett; Mike Petsche  
**Subject:** Re: D350-721-041

Hi Eric,

Yes, I would highly recommend a dimensional inspection of the frame before the mesh goes onto any basket. You have to do it at somepoint in the process, so we might as well do it earlier rather than later to avoid situations like this.

David

Sent from my BlackBerry device on the Rogers Wireless Network

---

**From:** Eric Downing <edowning@dartaero.com>  
**Date:** Thu, 13 Oct 2011 19:36:18 -0400  
**To:** David Shepherd <dshepherd@dartaero.com>  
**Cc:** Marc Bellavance <mbellavance@dartaero.com>; Lacelle, Linda <llacelle@dartaero.com>; Fauteux, Melanie <mfauteux@dartaero.com>; Susanne Sheldon <ssheldon@dartaero.com>; Bill Beckett <bbeckett@dartaero.com>  
**Subject:** Re: D350-721-041